

Work Order ID 142661

Friday, March 11, 2016 12:38:07 PM

142661

Page 1

Item ID: 647.0112

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Bracket

Start Date: 3/28/2016/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 4/18/2016/9 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: **MAR 11 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.0100	A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

58

De 16/05/12

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

58

De 16/05/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐
☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing
☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat
☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short
☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled
☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish
☐ Misread	☐ Turning Sequence	OTHER : _____					
☐ Past Expiry Date	☐ Misidentified						
☐ Product Improvement	☐ Process Improvement						
☐ Manufacturing Process	☐ Past Due						

Work Order ID 142661

Friday, March 11, 2016 12:38:07 PM

142661

Page 2

Item ID: 647.0112

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut Bracket

Stop ***NS2***

Start Date: 3/28/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 4/18/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

DAS
38
9-89

MAY 12 2016

130

Form as per dwg

0.01

130

Brake NC

NC BRAKE

Memo

0.01

Brake NC

USE DT9834 FOR FORMING

DAS
30
9-89

MAY 12 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.01

Quality Control

DAS
38
9-89

MAY 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 142661

Friday, March 11, 2016 12:38:07 PM

142661

Page 4

Item ID: 647.0112

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut Bracket

Stop ***NS2***

Start Date: 3/28/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 4/18/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.05

Quality Control

MCS MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Friday, March 11, 2016 12:38:11 PM

Page 1

Work Order ID: 142661

142661

Parent Item: 647.0112

647 0112

Parent Item Name: Strut Bracket

Start Date: 3/28/2016

Required Date: 4/18/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	43.1000	0.0325	1.026315			

M304S14GA

304SS sheet .080

PC 16/05/12

Location

Loc Qty

Loc Code

MAT019

43.1

M129972

43.1

1.75

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985				SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13		EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: SHEET METAL					
	APPROVED BY: ENGR.		MFG		QC	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED NOTE 2. ADDED 647.0117				
EFF. NEXT ORDER						

IS

NOTES:

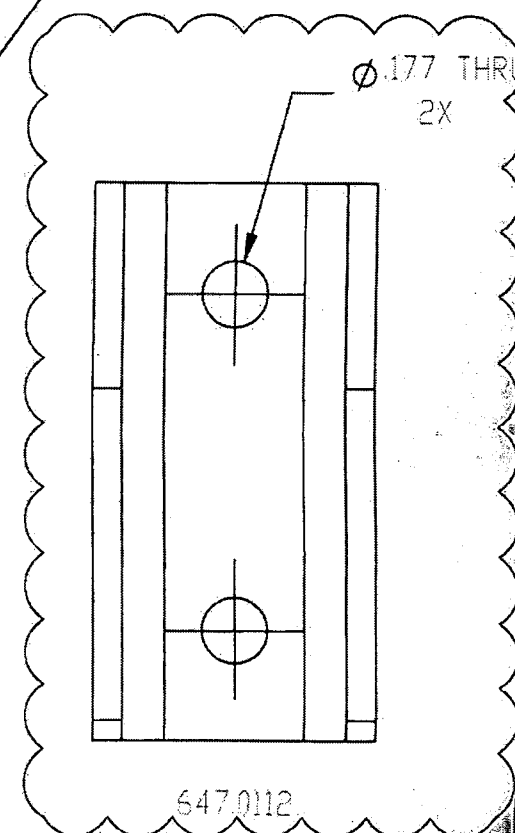
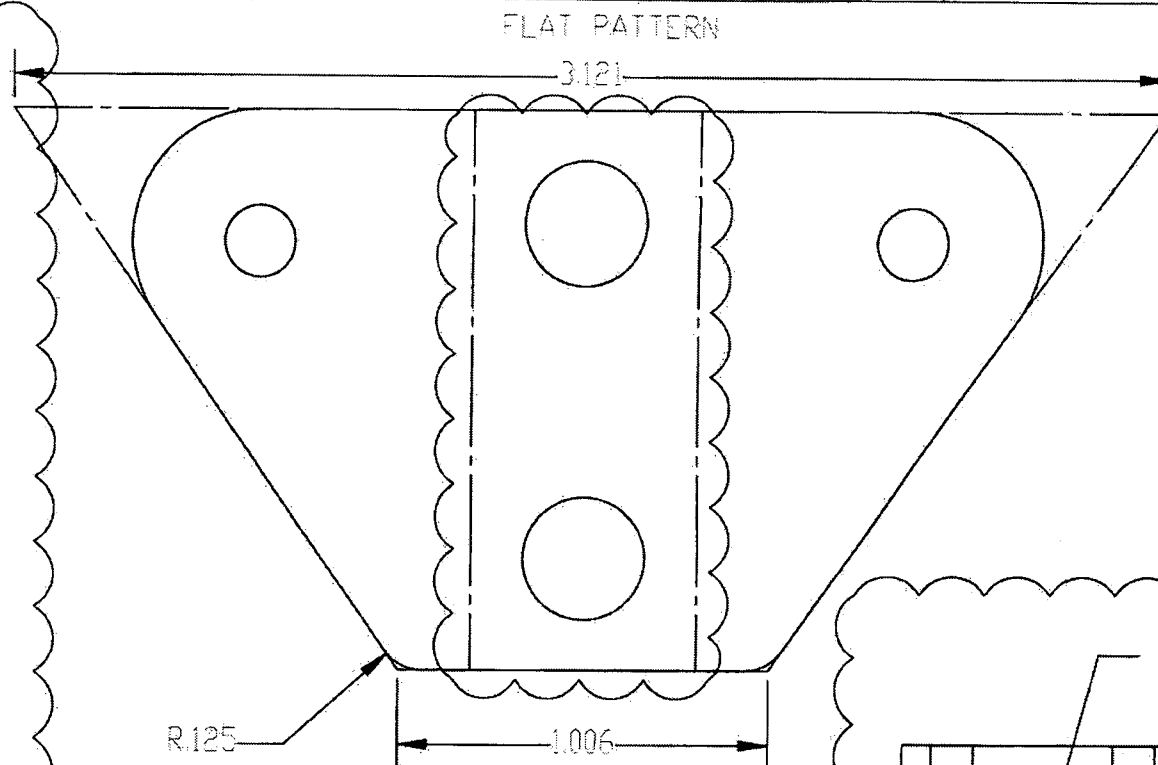
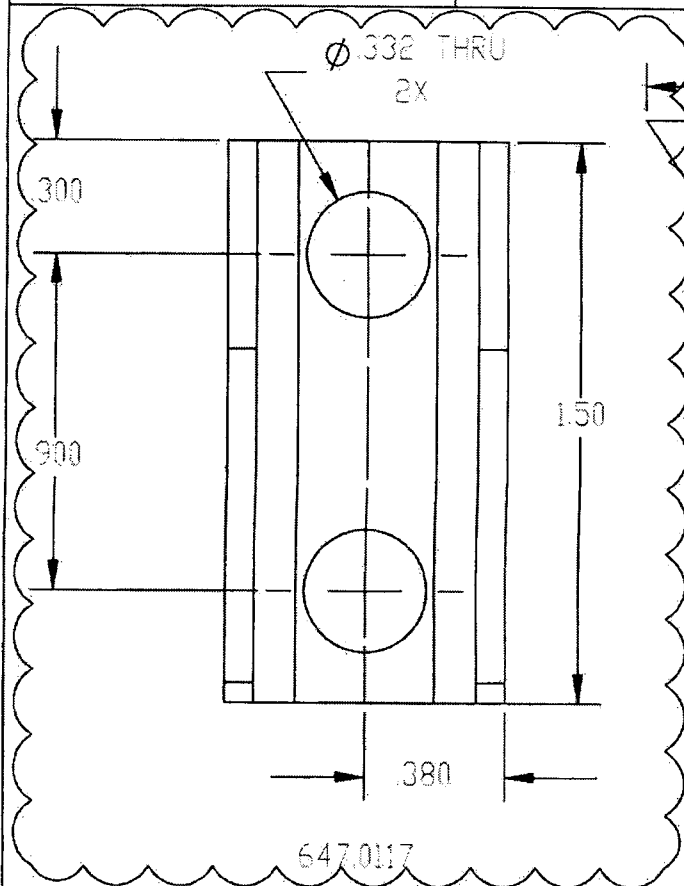
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.

2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 142661 MJS
 1603-11

SHEET 1, ZONE D1 IS:

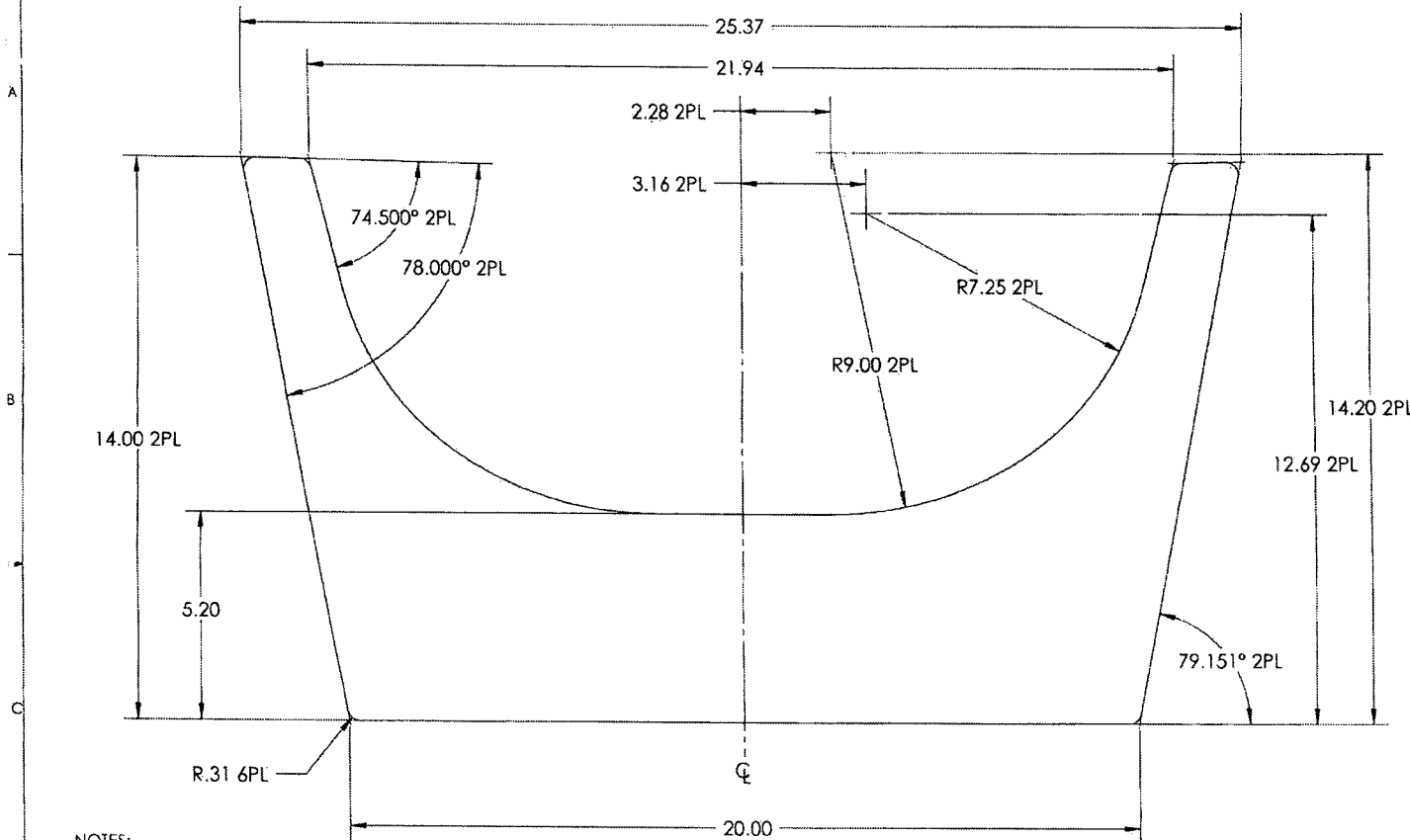
	C	647.0117			STRUT BRACKET	△	△
F/N	T/C	PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION		
DOCUMENTS EFFECTED:						CHANGE CATEGORY	
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM						☐ MAJOR ☒ MINOR	
						DER REVIEW REQUIRED	
						☐ YES ☒ NO	



SHEET 3, ZONE B2-4 IS:

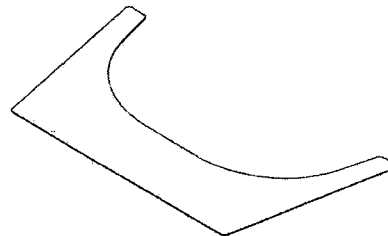
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: R92		N/C
2	INITIAL RELEASE	03/28/09	P. BRAYO
3	INCORPORATED ECN 02777, 02944, 03009	04/26/11	P. BRAYO



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



647.0110

UNINCORPORATED ECN(S)

03985

		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
		FIND #	PART #	DESCRIPTION	MAT'L SPEC.
QTY		PARTS LIST			
NEXT ASSY (S)		ORIGINAL DATE: 05-28-07			
646.9500		DRAWN BY: J. ROSARIO			
		DRAWING APPROVAL: P. BRAYO			
		CONTRACTING:			
		UNLESS OTHERWISE SPECIFIED			
		DIMENSIONS ARE IN INCHES			
		TOLERANCES ARE:			
		2 PLACE DECIMALS ± .01			
		ANGLES ± .5°			
		SCALE: NONE			
		SHEET 1 OF 6			

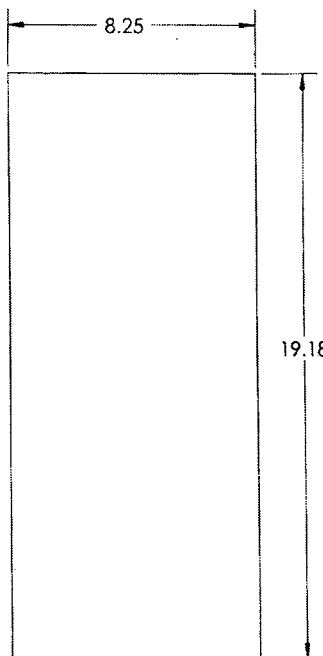
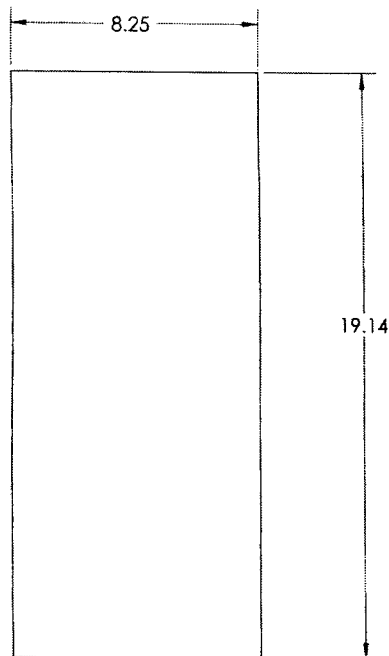
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

SHEET METAL

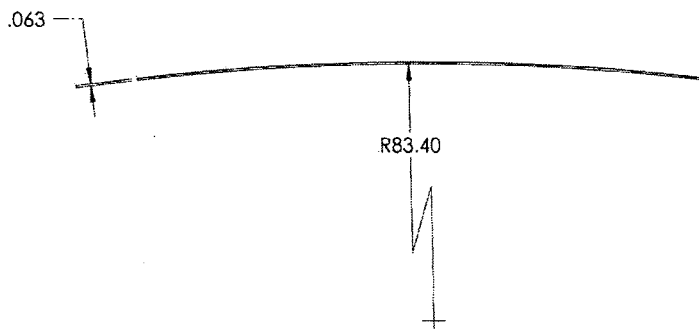
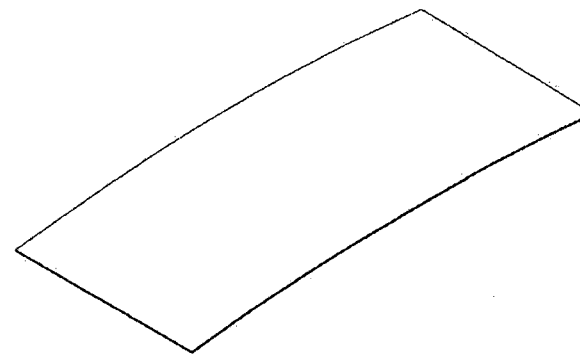
647.0100

REV. A

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



FLAT PATTERN



SPECIAL DATE 11-03-91 01:25:29		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY B. ROSANO	CHECKED P. BRAVO	SHEETMETAL	
DRAWING APPROVAL P. BRAVO		SHEET B	REV. A
CONTRACT NO.		CAGE CODE D7M25	DWG. NO. 647.0100
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES SPACES ARE 7 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		SCALE: NONE	SHEET 2 OF 6

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REV.	DESCRIPTION	DATE	APPROVED

Ø.177 THRU
2X

FLAT PATTERN

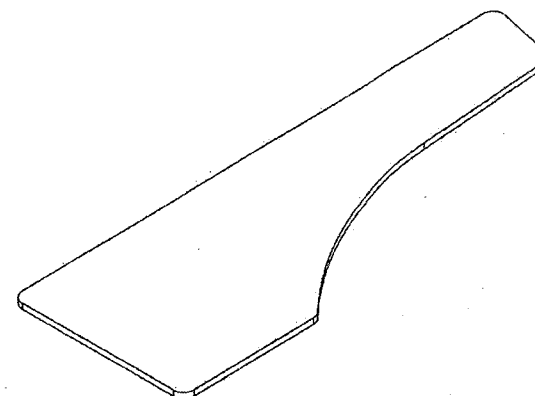
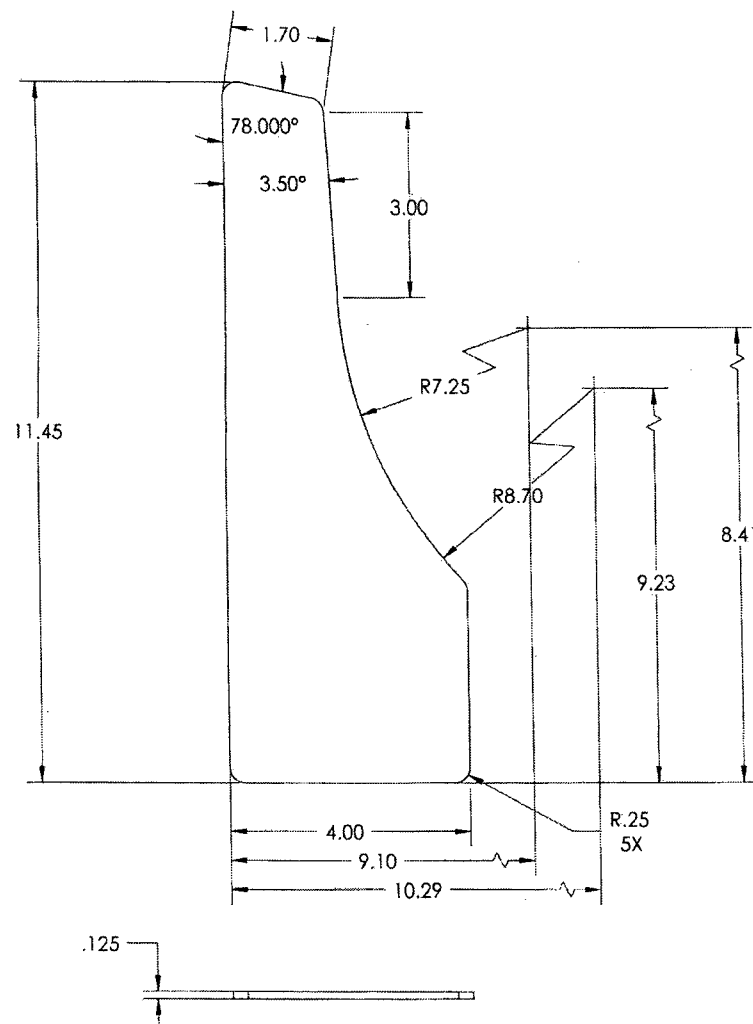
647.0112

Ø.191 THRU
2X

ORIGINAL DATE 10-28-07	APICAL INDUSTRIES		
DRAWN BY R. ROMANO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
CHECKED BY P. BRAVO	SHEETMETAL		
DRAWING APPROVAL P. BRAVO	REV. 1	DATE CODE 07M26	DWG NO. 647.0100
CONTRACT NO.	SCALE NONE		SHEET 3 OF 4

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

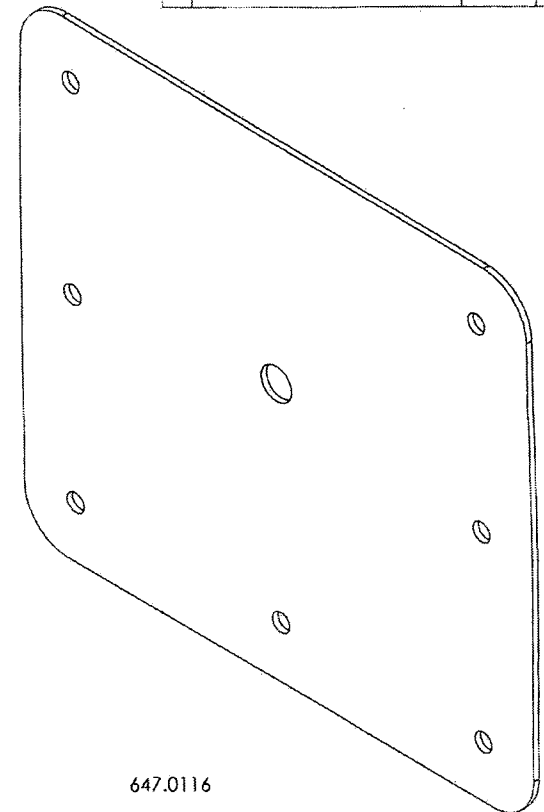
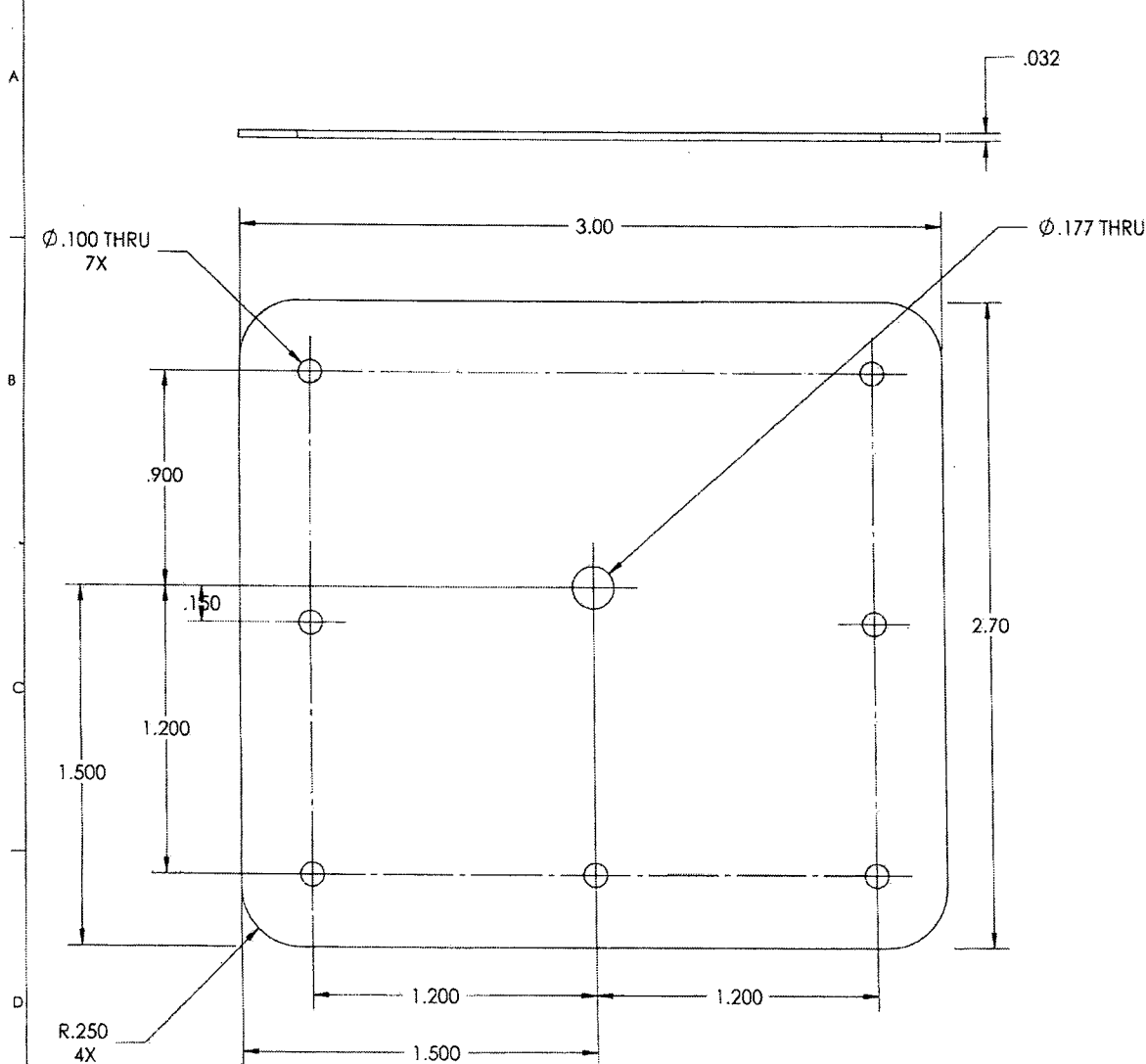


647.0113

ORIGINAL DATE 1/10/2011 05:28:05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWN BY P. ROSANO	CHECKED BY P. BRAY		
DRAWING APPROVAL P. BRAY 05/28/20		SHEETMETAL	
CONTRACT NO.		647.010J	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.1°		SIZE [CAGE CODE] B 07M26	REV A
SCALE NONE		SHEET 4 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE 10-04-91 05:28:00		APICAL INDUSTRIES	
DRAWN BY W. ROSANO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY P. BRAVO		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SHEET CODE R 07M26	REV A
DWG. NO. 647.0100		SCALE NONE	
SHEET 6 OF 6			